

March-07-12 2:24:56 PM

81055

Page 1

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Start Date: 07/03/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 21/03/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/07 Tooling:

Date:

Run Start *NR1*

QC: _____

Date: _____ **SPC (Y/N):** _____

Date:

Stop *NR2*

Draw Nbr	Revision Nbr
D2604	Rev B

100

0.00

100

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2604 Dwg Rev: **B** Prog Rev: **B** 2-

Deburr if necessary

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Hand Finishing

W/O:		WORK ORDER CHANGES					
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81055

March-07-12 2:24:56 PM

N900040100

Setup Start *NS1*

Stop *NS2*

4

4

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

0.00

160

0.00

4x4 m/s 12/03/30

0.00

170

0.00

(4X) SP 12-03-30.

0.00

180

0.00

12/4/2018

012-03-30

W/O:		WORK ORDER CHANGES					
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Picklist Print

March-07-12 2:25:00 PM

Page 1

Work Order ID: 81055

81055

Parent Item: D2604-1

D2604-1

Parent Item Name: Console Side LH, 407 Console

Start Date: 07/03/2012

Required Date: 21/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP C98.11.25 Added Inspection Levels, Jig numbers DM
IPP Rev: D 07-09-24 Now On Waterjet JLM Verified By: EC
IPP Rev: E 07-12-18 ECN1059 RevB as per dwg DD verified by EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.040		Purchased	No			100	sf	226.2284	1.3472	5.672421			
										**		12-03-28	
M2024T3S 040													
2024-T3 .040 sheet													

Location

Loc Qty

Loc Code

MAT022

226.228421

117684

26.318421

120196

59.41

120605

140.5

W/O:		WORK ORDER CHANGES					
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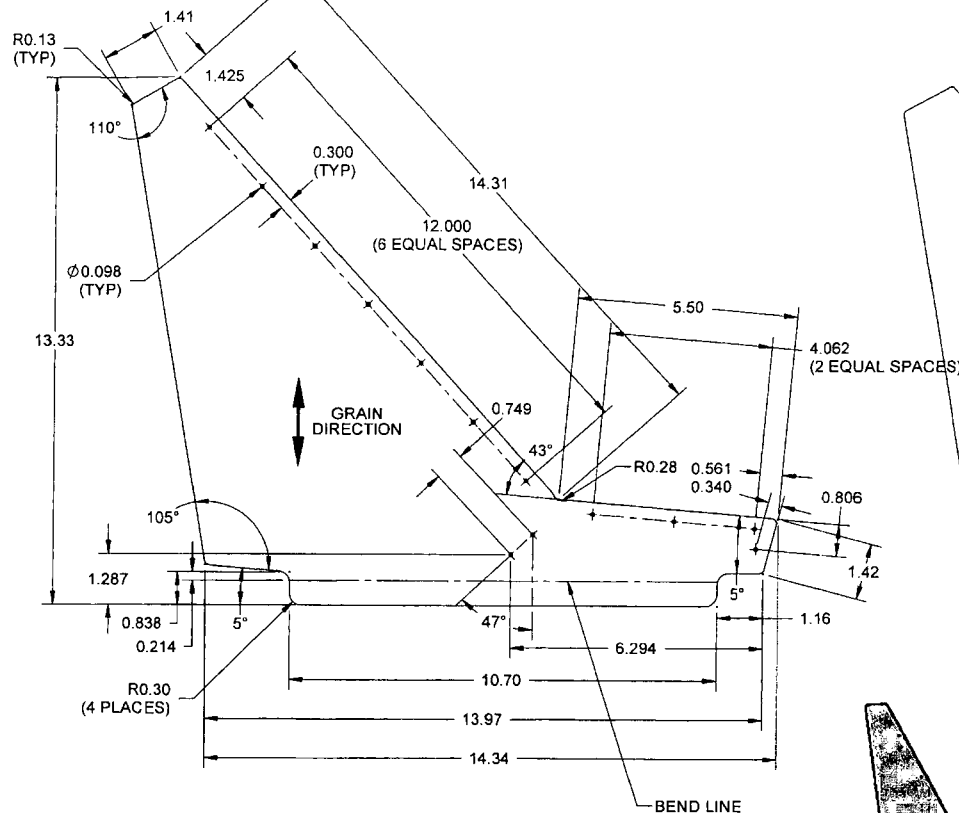
W/O:		WORK ORDER CHANGES					
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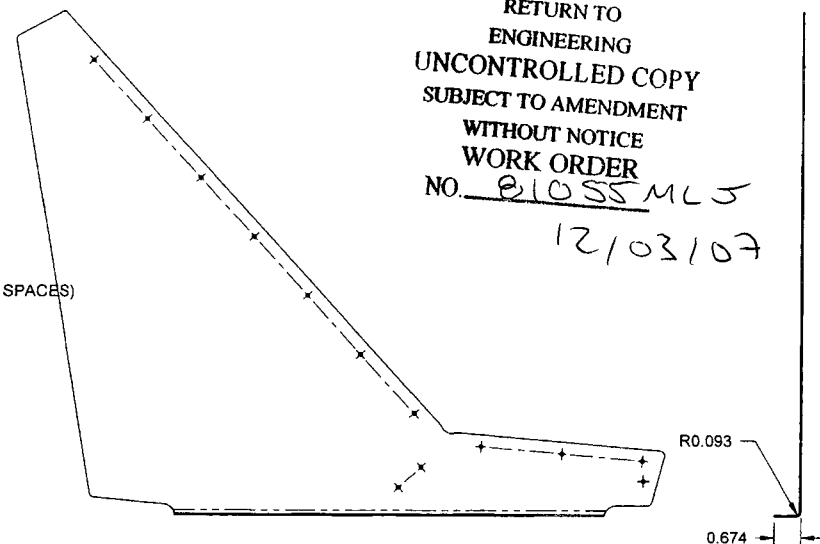
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D2604-1F FLAT PATTERN



**D2604-1 CONSOLE SIDE (MAKE FROM D2604-1F)
(D2604-2 OPPOSITE)**

RELEASED
07.12.12

- NOTES:**
- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.040 THICK PER QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.040)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.36 lbs

B	ADD GRAIN DIRECTION, UPDATE DIMS, GENERAL UPDATE, INCORPORATED HAND CHANGES	DC	07.11.07
A	D2604 WAS D206-547-231-24	BW	97.10.24
REV.	DESCRIPTION	BY	DATE
DESIGN	JB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	BC		
CHECKED	UE	DRAWING NO.	REV. B
MFG. APPR.		D2604	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CONSOLE SIDE	1:3
DATE	07.11.07	<small>COPYRIGHT © 1997 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR CONTAINED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

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